

gpi
Work Order ID 61883-2

Wednesday, September 08, 2010 3:27:43 PM

~~PRELIMINARY ISSUE~~ 6.10.10.01



Page 1

Item ID: D4175-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod GPS Doubler Assembly

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *PAI*

Date: 10-9-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4175	PA1								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	1-Cut as per Dwg (D4175-1F)								
	Dwg Rev: <i>PAI</i>								
	Prog Rev: <i>PAI</i>								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	Memo	0.00							

1B10-9-13

3

1B10-9-13

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Page 2

Item ID: D4175-041

Accept

Revision ID: PRELIM

Item Name: Pod GPS Doubler Assembly

Setup Start

Stop

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

inspected to PA1

Dwg only

QC

Memo

0.00

8/10/09/13 (x3)

Quality Control

130

0.00

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

8/10/09/13 (x3)

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/09/13 (x3)

inspected to PA1

Dwg only

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Page 3

Item ID: D4175-041

Revision ID: PRELIM

Item Name: Pod GPS Doubler Assembly

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-9-14

Memo

0.00

3

0

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/11/2588

Memo

0.00

24 10/09/15

3

0

Start Time: 2:45pm
Oven Temperature: 320°C
Finish Time: 3:12pm

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

inspected by

Memo

0.00

Done by
8/10/09/16

POSITIVE RECALL

EFFECTIVE

10/9/04

AUTH

RELEASED

DATE

10.10.01

PER RELEASE DWH
DATED 10.09.24

Work Order ID 61883

Wednesday, September 08, 2010 3:27:43 PM



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Item ID: D4175-041
Revision ID: PRELIM
Item Name: Pod GPS Doubler Assembly

Accept



Setup Start



Stop



Start Date: 9/8/2010 Start Qty: 3.00
Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Small Fab

Small Fab

Memo

1- Install nut plate as per dwg

0.00

0.00

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

9/8/09/16 (3)

*- inspected to PA1
Dug only
8/10/09/16 (NS)*

composites

Refill

ET 10-10-01 (f2)

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Item ID: D4175-041

Accept



Setup Start



Revision ID: PRELIM

Item Name: Pod GPS Doubler Assembly

Stop



Start Date: 9/8/2010 Start Qty: 3.00



Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04

PS10-10-01 (2)

Picklist Print

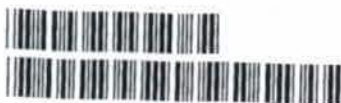
Wednesday, September 08, 2010 3:27:48 PM

Page 1

Work Order ID: 61883

Parent Item: D4175-041

Parent Item Name: Pod GPS Doubler Assembly



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	104.9340	0.053	0.167368			
6061-T6_063.Sheet													

Location

MAT21

113608

Loc Qty

104.934

104.934

Loc Code

MS20426AD3-3

Purchased

No

180

Each

5,021.000

8

24

Rivet

Location

ST316

19099

7681

Loc Qty

5021

4774

247

Loc Code

MS21075

Purchased

No

180

Each

0.0000

4

12

Nutplate

1105978

12

3

113608

24

8/10/09/16

24

12

8/10/09/16

24

12

8/10/09/16

24

12

8/10/09/16

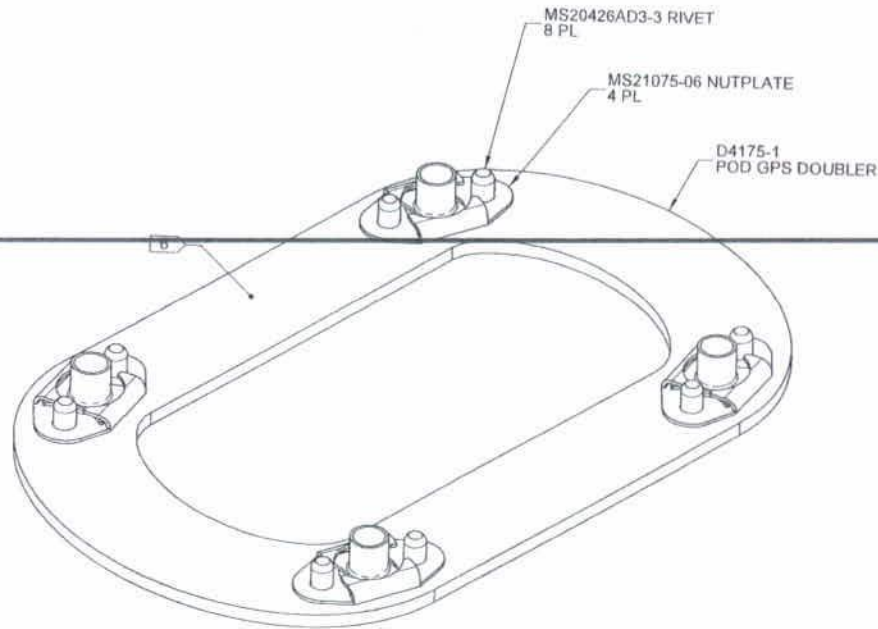
24

12

8/10/09/16

Route 12m / Ax F
 12m

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4175-041	POD GPS DOUBLER ASSY
1	1	D4175-1	POD GPS DOUBLER
2	4	MS21075-06	NUT PLATE
3	8	MS20426AD3-3	RIVET



D4175-041 POD GPS DOUBLER ASSY

41883
 10 9-09
PRELIMINARY ISSUE
 10.09.08

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

PA1	NEW ISSUE	MB	10.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.01		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

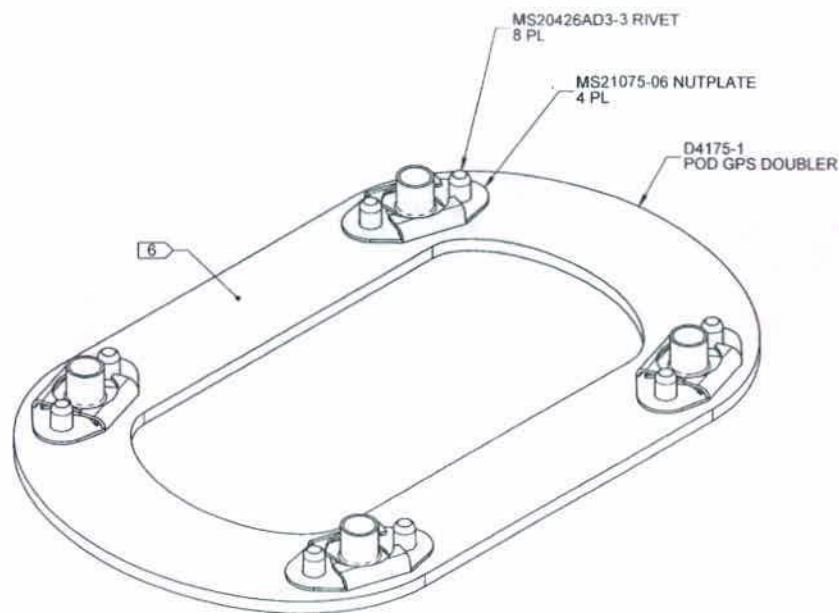
DRAWING NO. **D4175** REV. PA1
 SHEET 1 OF 2
 TITLE **POD GPS DOUBLER ASSY** SCALE NTS

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DART AEROSPACE LTD		Work Order:	61883
Description: Pod G.P.S. Doubled Assembly		Part Number:	D475-041
Inspection Dwg: D475-1 Rev: PA1			Page 1 of 1

☒ First Article ☐ Prototype

ITEM	QTY	P/N	DESCRIPTION
	X	D4175-041	POD GPS DOUBLER ASSY
1	1	D4175-1	POD GPS DOUBLER
2	4	MS21075-06	NUT PLATE
3	8	MS20426AD3-3	RIVET



D4175-041 POD GPS DOUBLER ASSY

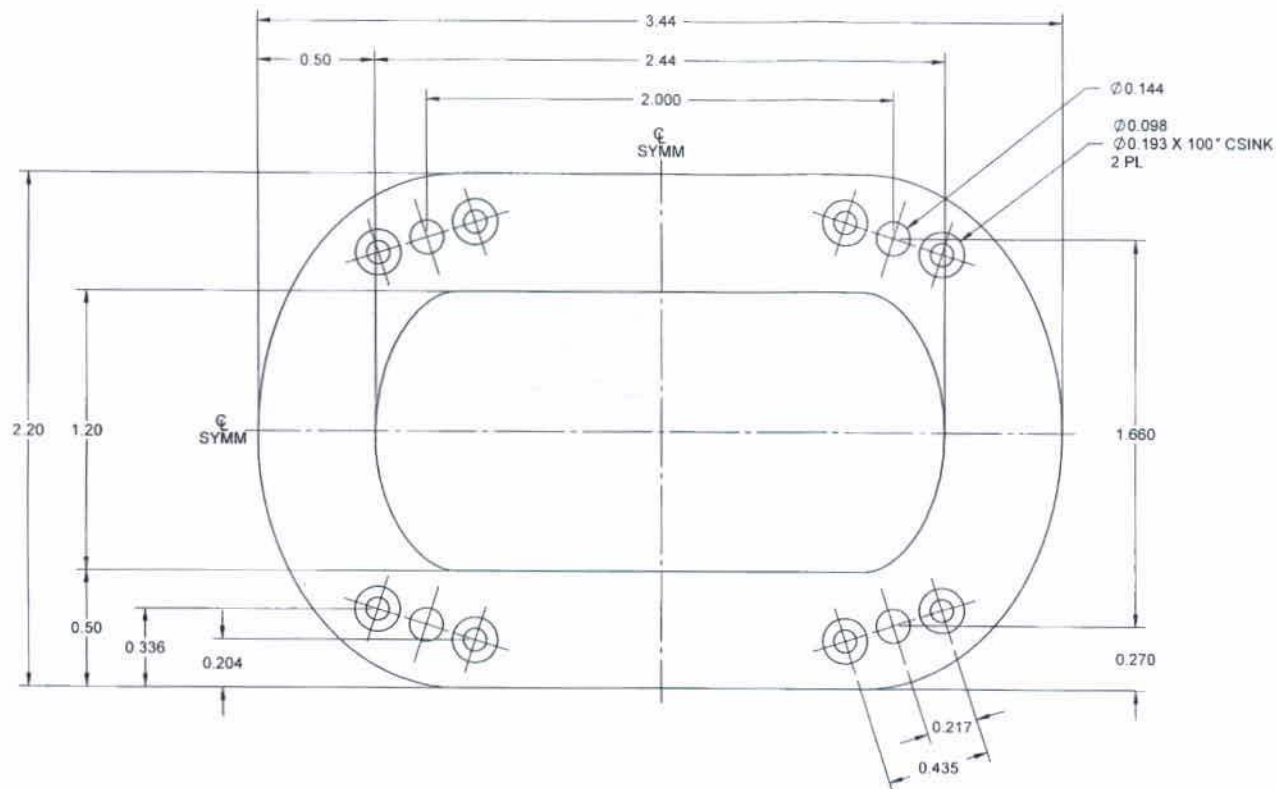
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	MB	10.09.01
REV		BY	DATE
DESIGN	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.	R	D4175	SHEET 1 OF 2
APPROVED	R	TITLE	SCALE
DE APPR.	R	POD GPS DOUBLER ASSY	NTS
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61883

RELEASED
2010-09-29
W



D4175-1 POD GPS DOUBLER

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S 063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.	R	D4175	SHEET 2 OF 2
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